

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76889

76889

Page 2

November-22-11 3:25:25 PM

Item ID: D3622-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ball Stud
 Start Date: 22/11/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 06/12/2011 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>070</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Ca/12/15 *(40)*

11/12/15 *ME*

11-12-05

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Picklist Print

November-22-11 3:25:29 PM

Page 1

Work Order ID: 76889

76889

Parent Item: D3622-1

D3622-1

Parent Item Name: Ball Stud

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-04-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500		Purchased	No			100	f	19.7545	0.108	4.547368			

M303H0 500

303 HEX BAR .500

**

5.025'

11/12/03

Location

Loc Qty

Loc Code

MAT037

19.7545

109778

19.7545

5.025'

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DART AEROSPACE LTD		Work Order:	76889
Description: Ball Stud		Part Number:	D3622-1
Inspection Dwg: D3622	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.58	+/-0.030	0.564	✓		SLOP SLOZ	
0.50	+/-0.030	0.499	✓		"	
Ø0.394	+/-0.010	Ø0.395	✓		"	
Ø0.310	+/-0.010	Ø0.3103	✓		"	
Ø0.215	+/-0.010	Ø0.215	✓		"	
0.155	+/-0.010	0.156	✓		"	
0.313	+/-0.010	0.313	✓		"	
0.478	+/-0.010	0.479	✓		"	
0.630	+/-0.010	0.630	✓		"	
0.125	+/-0.010	0.125	✓		"	
0.563	+/-0.010	0.562	✓		"	
1.19	+/-0.030	1.186	✓		"	
0.3125-24UNF-3A	+0.000/-0.072	0.312 NF	✓		"	
M.O.W.	Min = 0.3336 Max = 0.3363	0.3354	✓		"	

Measured by:	<i>[Signature]</i>
Date:	11/12/03

Audited by:	<i>[Signature]</i>
Date:	11-12-3

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	
B	10.02.02	Dwg Rev updated	KJ	
C	11.02.18	Dimensions updated per Dwg Rev C	KJ <i>[Signature]</i>	<i>[Signature]</i>

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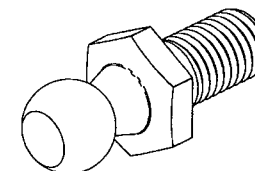
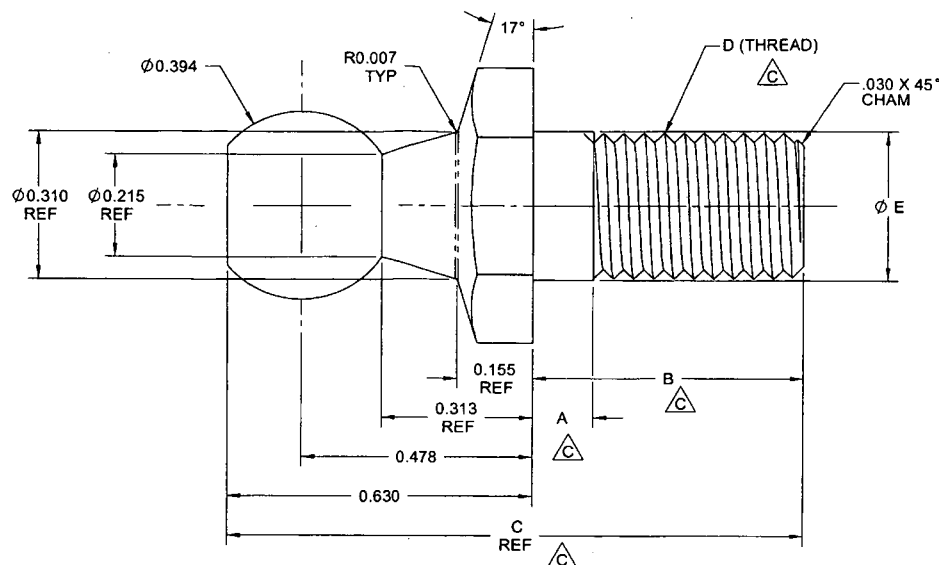
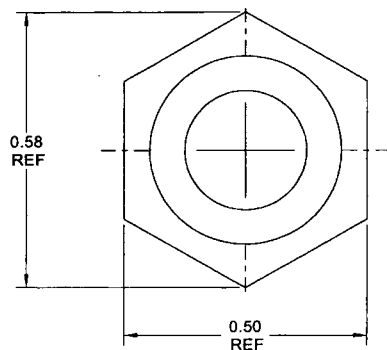
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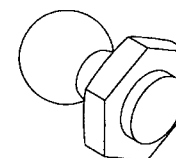
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8 7 6 5 4 3 2 1



**D3622-1 BALL STUD
SHOWN**



**D3622-11 BALL STUD
SHOWN**

PART NUMBER	DIM A	DIM B	DIM C	WEIGHT (LBS)	THREAD D	Ø E	
						MIN	MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053	0.3125

D3622-X BALL STUD



RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
76889 M.C.J
11/11/22

- NOTES:
- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
 - 7) WEIGHT: SEE D3622-X TABLE

RELEASED
2010-09-23

C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3622	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BALL STUD	NTS
DATE	10.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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